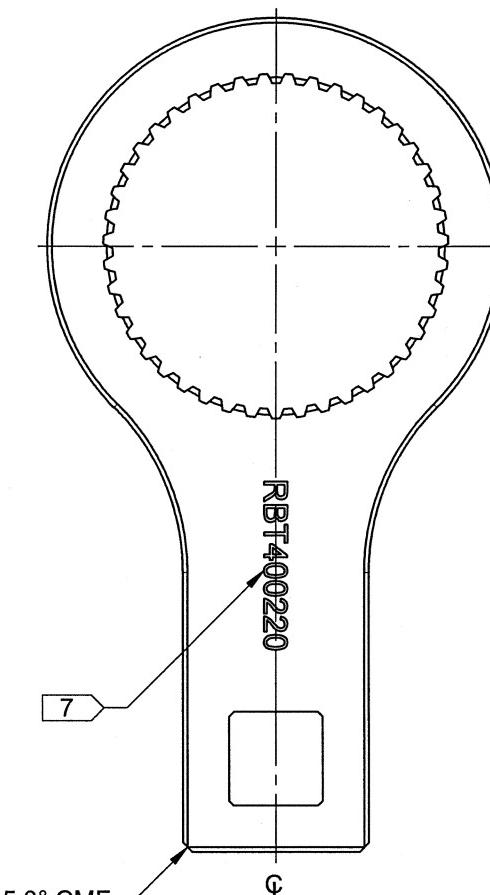
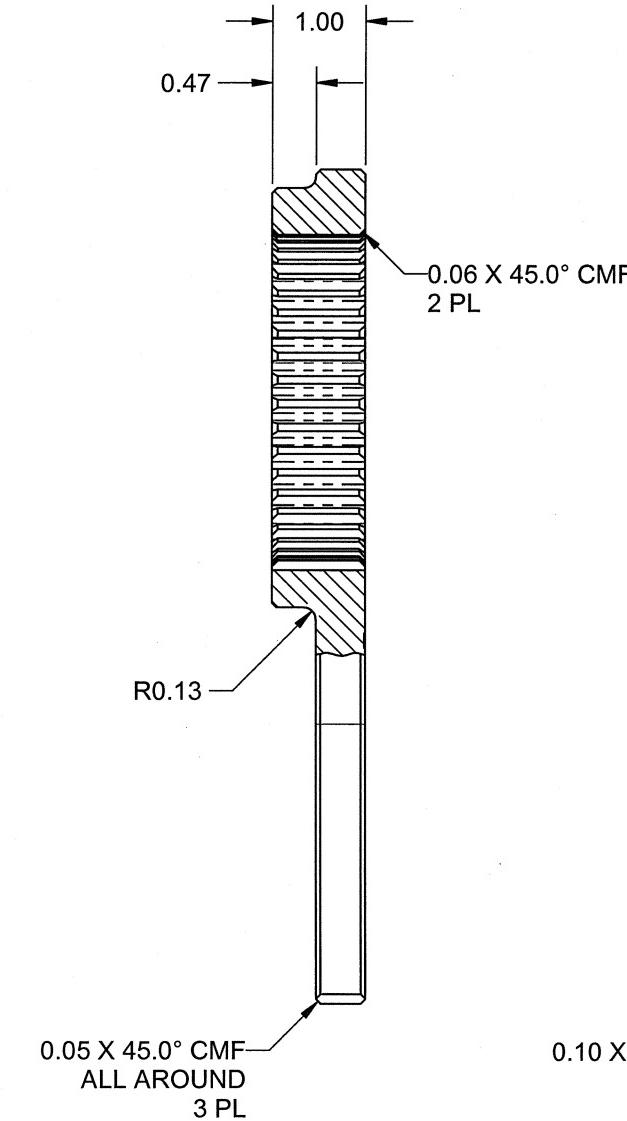
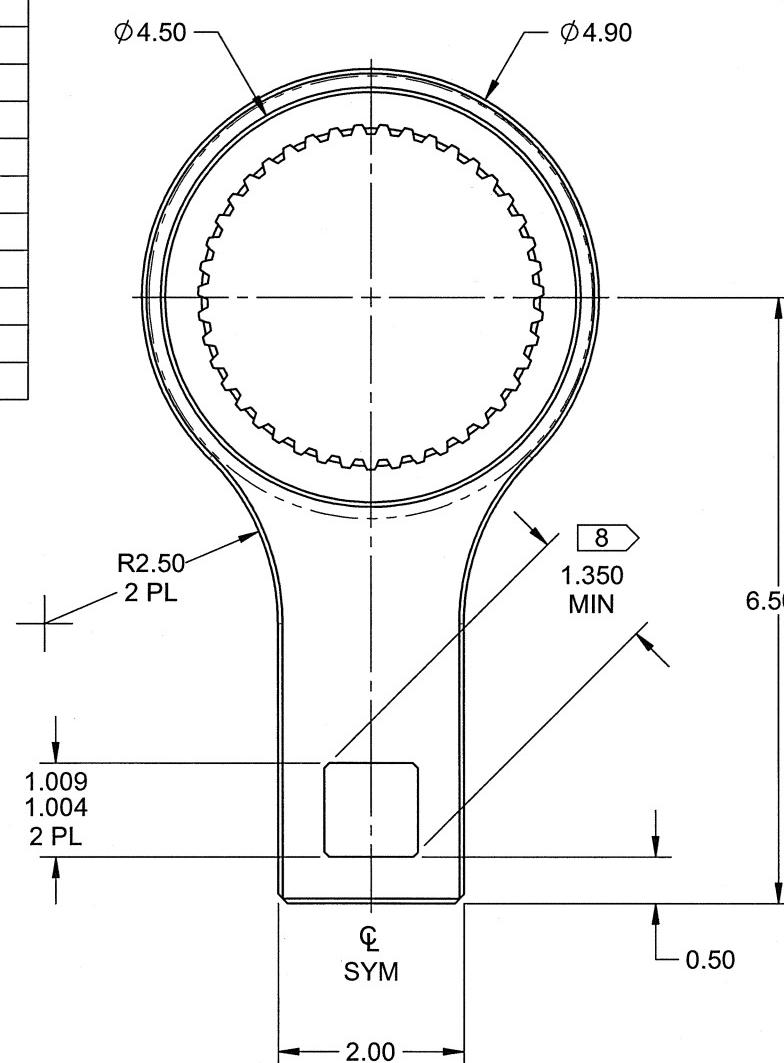
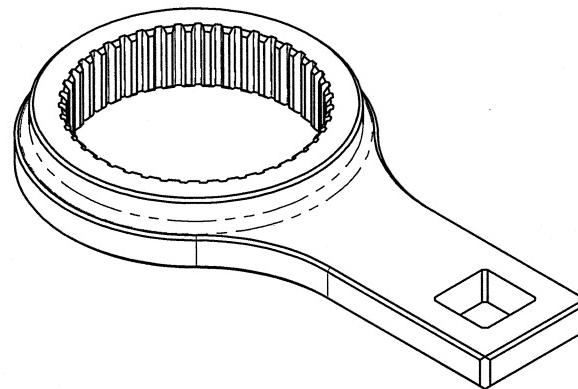


**INTERNAL INVOLUTE SPLINE DATA**
**FLAT ROOT SIDE FIT**

|                                    |              |
|------------------------------------|--------------|
| NUMBER OF TEETH                    | 43           |
| SPLINE PITCH                       | 12/24        |
| PRESSURE ANGLE                     | 30°          |
| BASE DIAMETER                      | 3.103258 REF |
| PITCH DIAMETER                     | 3.583333 REF |
| MAJOR DIAMETER                     | 3.700 MAX    |
| FORM DIAMETER                      | 3.674        |
| MINOR DIAMETER                     | 3.505/3.500  |
| MAX ACTUAL CIRCULAR SPACE WIDTH    | 0.1346       |
| MIN EFFECTIVE CIRCULAR SPACE WIDTH | 0.1309       |
| MAX MEASUREMENT BETWEEN PINS       | 3.3807 REF   |
| PIN DIAMETER                       | 0.1440       |


**RBT400220 WRENCH**

9 > 10 > 11  
12 > 13

**NOTES:**

- 1) MATERIAL: O1
- 2) HEAT TREAT: 35-40 Rc
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT400220", AS SHOWN
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY
- 9) DIMENSIONS MUST BE MET AFTER PLATING
- 10) INSPECT THE INTERNAL INVOLUTE SPLINE USING THE DT10522 GO GAUGE AND THE DT10523 NOT GO GAUGE
- 11) THE INTERNAL INVOLUTE SPLINE MUST FIT WITH THE DT10522 GO GAUGE  
WITHOUT LOOSENESS OR INTERFERENCE THROUGHOUT THE LENGTH OF ENGAGEMENT
- 12) THE INTERNAL INVOLUTE SPLINE MUST NOT FIT WITH THE DT10523 NOT GO GAUGE
- 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

|                        |   |  |                       |
|------------------------|---|--|-----------------------|
| D                      | SEE PREVIOUS REVISIONS FOR MORE INFORMATION<br>UPDATED DRAWING TEMPLATE<br><br>FINISH WAS CAD. PLATE YELLOW IS ZINC PLATE (YELLOW OR BLACK). REVISED GEAR DATA. REMOVED .53, 5.500, 1.0, 4X .05 X 45°, Ø3.500 ± .002, AND Ø3.390 ± .002 OVER Ø.143 PINS DIMS. ADDED 0.47, 0.50, AND 6.500 DIMS, MATERIAL WAS 4140 RC 32-37 IS O1 RC 35-40 | 19-790   | KPT                   |
| REV.                   | DESCRIPTION   | ECN #  | BY                    |
| DESIGN<br>DRAWN        | KPT   | <b>DART AEROSPACE LTD</b>  |                       |
| CHECKED                | MBB   | HAWKESBURY, ONTARIO, CANADA  |                       |
| MFG. APPR.<br>APPROVED | DP<br>WJ  | TOOL PART #<br><b>RBT400220</b>  | REV D<br>SHEET 1 OF 1 |
| TITLE<br><b>WRENCH</b> | SCALE<br>NTS  |  |                       |
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